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NOVEMBER 24, 1928

Issued Weekly

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VOLUME
XXV

Special Features

The Cirrus Mark III

The Military Value of Airships

Use of Monel Metal and Nickel in Aircraft

NUMBER
22

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AVIATION

The Oldest American Aeronautical Magazine

Vol. XXV

NOVEMBER 24, 1928

No. 28

Slotted Wings

A NUMBER of De Havilland "Moths" and Avro "Avians" with slatted wings have been imported into this country, and in addition the Navy Department has equipped some of its planes with slots. The opinions expressed thus far, however, by those who have piloted the slatted wing planes, vary widely as to the actual value of the slot device.

The slotted wing has been under development for many years. The idea originated almost simultaneously in England and Germany, and a somewhat similar idea to the slotted wings apparently was tried in the Argentine. The first slot device extended the full length of the leading edge of the wing, and were manually operated. Later, a slot on the trailing edge was added. Wind tunnel tests, made with wings equipped with these slots, showed a great increase in the maximum angle of lift and a long postponement of the stall. During the development of the slotted wing, the slot device was not seen to have been paired with such sugar, and, until the last year, comparatively few planes were built to include slots.

analysis of the results. It was found that the device could be constructed so that it could operate automatically. This discovery eliminated one of the greatest handicaps. When the hand operated type it had been learned that when the patient found himself in trouble, he would forget, or it would be too busy to use the device. Thus, the slots were practically valuable when most needed. Some experiments have been conducted with a view to extending the automatic slots to cover the entire length of the wing. However, on the authority of the cleared wing phase, both have and alarmed, the slots have been applied only to that portion of the leading edge in front of the ailerons.

The benefits derived from the use of slots are hard to suppress. The majority of pilots who have flown planes equipped with them admit the value of the slot device and say that maneuvers may be performed with such planes, which cannot be performed with others. At the same time, they also say that slots are dangerous if they are used without slots. The statements sound, and are, contradictory. Especially in the case experienced pilots, a plane fitted with slots looks peculiar. This is especially true in soaring. Many pilots also argue, that even though the curved wing plane can be better controlled beyond the stalling point, yet, if the added control is used, the plane will stall even more dangerous than one without the slots before.

When fitted to a plane with a thin wing section such as the R. A. F. 13, the slots seem to be of greater value than they are on a plane employing a thick wing section with a high lift and a delayed stalling point. Improvements in the balance of planes and their control at all angles of attack have been made much more rapidly, and have required greater attention than have wing slots. If the slot device is to be introduced successfully in the

country, it will have to show considerably greater advantages than it does now. Both the theoretical aspect and the practical application will have to be developed greatly before the device is accepted readily by the manufacturers and operators of modern types of plants.

Local Aeronautical Exhibits

DETROIT, last spring, had the courage to stage an art show at an abandoned shore. From the standpoint of the industry, the show was considered well worth while, even though the direct cost did not cover nearly the expense of the exhibition. From the point of view of the organizers of the show, it was a highly successful one, since the receipts considerably exceeded the expenditures. As a result, the professional show organizers all over the country decided that the time was ripe for raising money out of abandoned shows, and the members of the industry were bombarded by demands to place exhibits in the shows of inaccessible towns and villages.

Good publicity is an expensive form of "good will" advertisement, as far as manufacturers of aviation products are concerned, and there was naturally a strong aversion to the measure that was brought to trial. The industry, under the auspices of the Aeronautical Chamber of Commerce, met the situation by forming a public company of its own, and almost all of the manufacturers, large and small, took shares. The first was propitious, and the first exhibition to be held by the industry, through its own organization, is soon to be staged in Chicago. Finally, if there are any, will revert to the industry, and that is as it should be.

In the interim, it has been proved by Boston, Philadelphia and other cities, that local aeronautical shows can be both worthwhile and successful financially. National and local shows, however, should not be confused as to their nature and purpose. The local shows are organized by interested manufacturers either directly, or with the assistance of the local distributors. Local shows are run by and for the local dealers and distributors of planes and accessories. The expense to the manufacturers is nil, and the expense to the dealers is very small. The local shows are held during the fall or winter when work is slackened off a considerable amount, and equipment can be spared for these purposes. The gate receipts from a properly advertised local show are considerable and, besides the good sales to persons, there is a possibility of considerable direct sales to others who might not be reached otherwise.

Whether the industry through the Chamber of Commerce should investigate and sanction these local shows is questionable, but it certainly should not discourage them as a matter of policy. It should be realized that local shows can do much good by gradually creating, wherever they are held, a greater sense of "art consciousness."

Use of Monel Metal and Nickel in Aircraft

By ROBERT J. MCKAY AND ROBERT WORTHINGTON
Development and Research Department, The International Nickel Co.

IN view of recent developments in the use of monel metal and nickel for parts of an aircraft, and to give designing engineers a brief review of the properties of which the use of these metals is based, these paragraphs have been written. Monel metal and nickel have certain valuable mechanical properties to which attention has not been sufficiently drawn in former publications. Therefore, in this article rather more emphasis is put on these properties than would otherwise be the case.

Monel metal consists of 68 per cent nickel, 28 per cent copper, 2 per cent iron, and 1 per cent manganese, silicon and carbon. Both monel metal and nickel combine strength and stiffness with inherent resistance to the forms of corrosion encountered by airplane parts. This last characteristic is the most significant—the means of protection used with steel and the light alloys are not needed in the case of monel metal and nickel, and, even more important, the weakening of structural parts that accompanies even the slightest amount of corrosion is avoided. They are not subject to the intercrystalline embrittlement characteristic of cold-worked brass and of the light alloys, or to the pitting frequently occurring with the ferrous metals and the light metals. The assurance that pitting, or intercrystalline corrosion, will not take place is particularly desirable in airplane con-



A view of one of the all-monel metal pontoons made by Breckner & Co., showing the internal construction. This photograph was made before the hull covering was attached.

On a purely mechanical basis the light alloys, and the steels would satisfy the greater part of the requirements of the airplane industry. It is due to the fact that these mechanical properties are often modified by chemical deterioration that consideration of the corrosion-resisting metals, with more stable, though sometimes at first elastic inferior mechanical properties, is necessary.

Monel metal and nickel are being used to some degree at the present time in airplane construction. One example is the use of exhaust manifolds by several prominent airplane manufacturers, a use dependent on the resistance of monel metal and nickel to gaseous corrosion in the high temperature range. Neither metal rusts, of course, and the oxide film that some will form effectively prevents further penetration. The form of these manifolds has not been standardized, flexible hose and welded and riveted construction have been used.

The salt-water resistance of monel metal and nickel is well known. The U. S. Navy has recently had built by Breckner & Co. two all-monel metal pontoons, for use in tropical waters, on Vought airplanes. These floats do not exceed the weight of analogous drift floats by 10 per cent, and of course require no protective surface. Gasoline tanks, both of the pressure and gravity type, have proven successful. No corrosion is experienced in Australia, monel metal wheels, including rim, spokes, and hubs, are used. Monel metal strip has been successfully used on the leading edge of wooden propellers, and "Monel-plywood" is used on stressed beams. Gasoline and oil lines and miscellaneous stamped fittings are very largely applicable.

In galvanic contact with the light metals and steels,



One of the all-monel metal pontoons recently completed by Breckner & Co. for the U. S. Navy.

monel and nickel behave like copper, the brasses and the bronzes leading to accelerated corrosion of the light metals and steel. In good electrolytes like seawater, the use of two metals in contact is very dangerous. For parts in atmospheric exposure, also, the coupling of metal-oxide anodes in electrochemical behavior may be dangerous. Rainwater and moisture condensing on metal surfaces carry sufficient dissolved salts to make them effective electrolytes. Brass rivets, for instance, have been known to accelerate corrosion of steel sheet held by them in atmospheric exposure. It is possible to protect with paints the joint between dissimilar metals from corrosion, when such a couple is necessary.

The properties of steel are generally used as a standard in airplane as well as other construction. In this article, comparisons between steel and monel and



Five sets of airplane wheels constructed entirely of monel metal, except for the internal rivets which are of stainless steel tubing.

nickel are frequently made. The outstanding difference between steel and monel metal is the unqualified greater resistance of monel to almost all forms of corrosion. Therefore, among the uses where monel metal best fits are those where the lack of dependability of protective coats is serious.

In some of the ordinary mechanical properties, the monel alloys do not come up to monel, some of the lightest-weight alloy steels are better than monel. In impact resistance (toughness), monel is distinctly better than the commercial steels. Monel is a little over 10 per cent heavier per unit volume than the steel steels, but an appreciable part of this difference is counteracted by the protective coatings necessary on steels. E. A. Rich-

ardson has stated recently that for steel G2 an thick the weight of finish on both sides required by Navy specifications adds nearly six per cent to the weight and that the corresponding increment for aluminum may be as much as 15 per cent.

H. C. Kerr¹ in a recent paper has pointed out a valuable relation between various materials in respect to their tensile strength per unit weight. We are reproducing his table and corresponding values for monel (from McKelvey).

	T. S.	Dist.	Dist. (from 1000)
Steel (AISI 404)	49,000 psi	7.50	54
Aluminum alloy	30,000	7.00	75
Monel metal	30,000	7.00	75
Aluminum alloy	20,000	6.50	122
Aluminum alloy	15,000	6.00	169
Monel metal	15,000	5.50	216

In addition to the relation given, and, in the opinion of the writers, even more important than that are some parallel properties—weight relations for proportional limit, endurance limit, corrosion-fatigue limit, and impact strength. The figures for mechanical properties given in the accompanying table have been drawn from the papers of D. H. McKeown.² The relative value of these several properties—weight relations is difficult to judge, in fact, (as depends on the particular parts of airplanes for which the metal is to be used, and no one of them may be considered to the exclusion of the others).

The exclusive least property is considered by the authors one of the most important. In most cases, a given stress repeated a great number of times causes failure, and it is this stress which an airplane should be built to withstand. The endurance limits for monel metal are as follows:

Aluminum—about 35,000 psi
Hot rolled—about 35,000
Cold worked—38-50,000 (depending on the temper).
These are to be compared with a range of 14-18,000 psi for steel, varying with the temper. Values for various steel uses in the same range as those for monel and vary with heat treatment, for alloy steels somewhat higher.

¹McKelvey, H. C. J. R. S. M. E. Trans. Vol. 55, No. 10, 1935.
²McKeown, D. H. J. R. S. M. E. Trans. Vol. 55, No. 10, 1935.
³McKeown, D. H. J. R. S. M. E. Trans. Vol. 55, No. 10, 1935.
⁴McKeown, D. H. J. R. S. M. E. Trans. Vol. 55, No. 10, 1935.



Nuts, bolts, control parts and fittings made of monel metal and steel in airplane construction.

struction where weight must be kept down and close figuring on mechanical properties is necessary. The extent to which the strength of a metal part is lowered by pits is out of proportion to the actual decrease in section due to the pit; and in this fact lies the especial seriousness of it.

The Cirrus Mark III

*Production of This Four Cylinder Vertical Air Cooled Engine is
Soon to be Started in the United States*

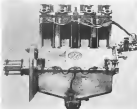
PRODUCTION in the United States of the Cirrus Mark III engine, now being used extensively abroad, is soon to be started by the American Cirrus Engine Co., New York, N. Y. Manufacturing rights have been obtained by the American company from A. D. C. Aircraft, Ltd., London, and arrangements are being made for the shipment to the United States of several surplus engines and of a complete set of parts, both in the rough and finished. Tools and jigs also are to be shipped.

Cirrus engines are now being produced in England at the rate of 20 a week and are being supplied to 25 different countries. At least 25 of the Cirrus engines are now in use in the United States. The Cirrus engine is particularly well adapted to installation in two passenger training planes, or in two and three passenger light commercial planes. Application of this power plant to small twin engine and tri-engine planes is also an interesting possibility.

The Cirrus Mark III is a four cylinder-in-line, vertical, air cooled engine, having a normal output of 85 hp at 1,600 r.p.m. and a maximum output of 95 hp at 2,400 r.p.m. The bore is 2.75 in., the stroke 3 in., the fly-

The joints between the cylinder and head, being made by copper and asbestos gaskets. The cylinder heads are directly removable without taking down the engine. The complete cylinder with head is secured in the crankcase by means of four studs projecting from the crankcase and passing through holes in the cylinder head.

In the cylinder heads special bronze seats for the exhaust and inlet valves are covered, and expanded in position. The valve guides, which are a force fit in the



A side view of the Cirrus Mark III engine

details, are of phosphor bronze. Provision is made in each cylinder head for two spark plugs, two bronze seawater bushes being fitted.

In the crown of each cylinder head, one inlet and one exhaust valve is fitted. Both valves are operated by means of push rods in conjunction with the tappet rods located in the upper part of the crankcase. The tappets are actuated directly by the camshaft. Rocker arms are carried on a separate steel bracket, which is bolted to the top of the cylinder heads.

The pistons are aluminum alloy castings, the crowns of which are adequately reinforced on the underside by cross webs. They are fixed with three piston rings at mid-noon. The lowest of these rings also acts as a scraper ring, as a groove is turned in the piston immediately below it, and a number of small holes are drilled around this groove through which oil can escape into the inside of the piston. This arrangement prevents any excess of oil on the cylinder walls from finding any way into the combustion chamber. The hollow piston pin is of the ball floating type.

The connecting rods are made from duralumin forgings of "H" section. The eye of the big end is secured to the rod by two bolts, and the big ends are fitted with die-cast aluminum bushings.

(Continued on page 1640)

The Military Value of Airships

By CAPT. F. L. M. BOOTHBY, R.N. (Ret.)

Member of the Royal Aeronautical Society

IT is a more or less current saying today, that "airships are of no military value." In the early days of the War, G. H. D., France and the War Office were of the opinion that armoured cars and tanks were also of "no military value." Today, they are absolutely highly important weapons. Similarly, with the lapse of a few more years, we may expect to see the airship take its proper place as the instrument of the future.

After the World War it was unfortunately that no officer with airship experience was appointed to the Air Council. Even today, no such officer has ever served on that body. The decision to abolish service airships was taken by men, who had no opportunity of understanding the harm they were doing, and the enormous amount of waste their decision would entail. They seem to have believed that the plane could undertake all the commercial air work required in the British Empire, and that they could build up a large reserve of aircraft by a system of subsidies. "Today we see the thirty—20 commercial planes." It is no use crying over spilled milk. Let us see what can be done to put the matter right, and to restore the airship to the position, from which it should never have been ousted.

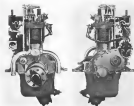
When a Committee of Enquiry into the Defects of Airships in the past is to be appointed, we might expect it to examine the defects such as follows and to suggest the necessary remedies.

(1) The airships employed by both the British and German navies were liable to destruction by incendiary bullets. Cause. The oxygen in the air and the hydrogen in the airship were separated from each other only by a layer

of fabric of paper thickness, and remarkably easy to get, when this layer was penetrated by a burning projectile. Remedy. If a layer of inert gas is interposed, between the oxygen in the air and the hydrogen in the gas bags, any of the existing types of incendiary bullets can be fired into the airship without burning it. Such a supply of inert gas is present in the exhaust from the motor, which can be cleaned and cooled at a small expenditure of weight, and used for the purpose. The objection to its use is that the gas is poisonous and precautions must be taken that it does not reach the living spaces if helium is available it can be used without the later objections.

(2) Airships were liable to damage by anti-aircraft fire supported by searchlights. Cause. Owing to the necessity of airships remaining in their bases in fine weather, to allow of their being placed in their docks, rails took place mainly in anti-cyclonic weather with clear skies, which was most suitable for the operation of guns and searchlights. Had it been possible, rails would have been carried out in cyclonic weather with low lying clouds, which would have completely unobscured guns and searchlights. As it was, the anti-aircraft fire was not a serious menace to airships. Remedy. Meeting these eyes now be made available for all airships, allowing operations in any weather.

(3) Rigid airships broke in the air. One of these was the "Dreadnaught," a ship of the L. 70 class. The R. 38 was a weaker section of the same class. Cause. The L. 70 class was designed for high flying. For every 1,000 feet (Corrected on page 1632)



Front and side views of the Cirrus Mark III Engine showing adaptability to efficient installation and cooling

placement 81 cu. in., and the compression ratio is 5.4 to 1. The weight of the engine dry is 280 lb. Its overall length is 29.5 in., overall height 23.1 in. and overall width 12.25 in. Fuel consumption is 54 lb. per hp hr. or approximately 7.5 gal. per hp hr., while the oil consumption is 10.2 lb. per hp hr.

Cylinders and cylinder heads are separate. The cylinders are constructed of cast iron and the heads of aluminum alloy with air-cooling fins cast on each. The cylinders are separated into the crankcase and into the heads



The U. S. S. "Los Angeles" riding at the towing tug erected on the U. S. S. "Pascata"

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The Military Value of Airships

(Continued from page 1621)

It, an airship ascends, it can carry 1-30 of its displacement, less the load. Assume the airship to be of 70 tons displacement, with a useful load of 35 tons. At 10,000 ft., the useful load would be reduced to 12 tons (without allowing for temperature corrections, and so forth, which permit of greater heights being reached with this load). If it was only intended to carry 12 tons, it was of no advantage to make the hull strong enough to carry 35, and so this was not done. In the K-36 and the "Zinn," maximum loads were carried.

The "Shenandoah" broke, because it was driven fast into heavy weather—it had to be driven fast to make the rudders and elevators effective. Had this airship been fitted with swiveling propellers, capable of driving it directly up or down at will it would not have been necessary to drive it as fast, and the ballast and gas would not



1 R-101 rigid plane "bowed" close up under the hull of the dirigible R-101. The plane was used in tests conducted by the British government to determine the practicability of launching and recovering heavier-than-air craft from rigid airships while in flight.

have been lost. Remedy: Revert to the pre-war practice of using swiveling propellers, and see that hull strength is made adequate. That this is possible, as proved by the "Los Angeles," which carries a full load at high speed.

(4) Airships have been lost owing to unaccounted high winds. The only example of this is the loss of German airships on England, where they met an unexpectedly high north wind. One was blown into the Mediterranean, two came down in France and the rest got home. Cause: The airships had stopped some of their engines when over England. These engines got so cold, and the crews were so exhausted after a long spell at 15,000 ft., that they could not start the engines. The crews that did manage to start all their engines got home safely. Remedy: A little hydrogen drawn from the gas bags makes any engine easy to start in any temperature. Apparatus for this purpose has been designed and fitted, and it works efficiently.

If it be granted that we can now obtain airships of the rigid and semi-rigid types, with their previous defects eliminated as indicated above, of what use can they be in war?

Let us consider an attack of the R-101 class, with a



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Build a good hangar, equip it with the best and you will have taken care of everything in the first cost. There never was a better time for building good airplane buildings than right now. The cost of maintenance on cheap buildings poorly equipped is too great. Look to the future, compare the costs, and the figures will show that it is more economical to build a good hangar with good doors, than it is to build "something that will do" and load yourself with an unbalanced upkeep.

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KINNEAR ROLLING DOORS

AVIATION
November 24, 1933

displacement of 180 tons, useful lift of 75 tons, and with engines of 4,000 hp, giving it a full speed of 70 knots. If we wish to employ it for reconnaissance purposes, the performance will work out much as follows:

Crew	3 tons
Food and drinking water	1 ton
Bullet	15 tons
Armament	5 tons
Fuel and oil	50 tons
	75 tons

The airship will consume some 4 lb. of fuel per horsepower per hour, so that it—

Full power (4,000 hp) the ship can fly for 70 hr. at 70 knots—4,000 mi.

½ power (3,000 hp) the ship can fly for 93 hr. at 60 knots—5,580 mi.

¼ power (2,500 hp) the ship can fly for 140 hr. at 49 knots—6,860 mi.

⅓ power (1,600 hp) the ship can fly for 280 hr. at 35 knots—9,800 mi.

¼ power (800 hp) the ship can fly for 560 hr. at 24 knots—12,440 mi.

It will be noted that six tons has been reserved for armament. This should allow an ample number of machine guns being carried, above and below the ship, to give any planes, approaching close enough to carry out a bomb attack, a very warm time.

Seeing that from a height of 6,000 ft. it is possible to see for 96 mi., there is no doubt it is possible to see for strategic reconnaissance as the large airship, which is capable of accompanying a fleet proceeding to any part of the world.

Airships As Plane Carriers

Suggesting aircraft carriers, as we have them today, are considered by some as very unsatisfactory craft. They are very expensive. It is necessary to load them with the most delicate and sensitive instruments, thereby the flying the fleet they are attached to or becoming detached from it. An airship, such as we are considering, would still have an ample radius of action if its fuel supply was reduced to 25 tons, allowing a direct aeroplanes to be carried. This is undoubtedly the best method of transporting planes from place to place in peace or war. It is also possible to release planes from an airship, and for them to fly back, but not in the numbers it is often supposed. An airship of 180 tons should be able to maintain a steady height, when flying fast, at sea level or high. This, supposing we are carrying near two-ton planes, the airship is flying at 5,000 ft. and is sea level heavy. When we have released three planes it will be in equilibrium, and we can release the next three if it becomes too light. Should we dispatch another group of these planes, it would be impossible to keep the airship down. It would rise until she had blown off gas equivalent to six tons.

When our planes return, the first three would put the airship in equilibrium again, the second three would make it six tons heavy, and it could just maintain its height. The third set of three would make it six tons heavy, and bring it down, unless the airship carried sufficient ballast to counteract this, which it would do on the 25 tons we have allowed for planes and their equipment.

The best of this class of airship used as aeroplane carriers is, therefore, likely to be twelve machines for transport purposes and nine for active employment. It should be easily possible to construct such an airship for \$5,000,000, so that for the cost of one seaplane carrier, we get 21 airships capable of carrying 180

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ground being available for landing, would have disappeared, but having been employed as cargo carrying craft and for evacuating the sick.

It is hoped that it has been possible to show that there is some future for the airplane from a military point of view, and that economy and efficiency can be attained.

The Cirrus Mark III

(Continued from page 1020)

white metal bearings. On the back of the cap a dowel is provided, cast integral with the bearing, which registers into a recess in the cap and prevents the bearing from turning. As an alternative, phosphor bronze white metal lined lag and bearings can be supplied. The four-throw crankshaft is of solid construction, and an extension flanging the propeller shaft is secured to the forward end by means of a forged cone hub and bolts. The complete shaft consists in five bearings. Three of these are the cast white-metal cone bearings, and the other two are the roller bearings at each end. The caps for the roller bearings and cone bearings are carried by the upper half-crankcase, and are secured by studs and nuts. The caps are steel and of rugged construction.

The crankcase is an aluminum alloy casting, divided along the center line of the crankshaft. The upper portion is reinforced by three transverse webs, which also form the bearings for the cone bearings. Hangers likewise are provided in the upper portion for carrying the camshaft bearings and the upper oil pump spindle bearings. Provision is made also for securing loose bearing or supporting lens. Bearings for the ball bearings carrying the timing gears are provided in the upper half and the gear drive shaft. On the lower half above the lower oil sump casting is secured, which acts as an oil filter, and to which breather pipes are attached.

The lower half, beyond forming in half a cap for the radial thrust bearing, merely acts as an oil sump and a cover for the lower half. The upper and lower portions are bolted together, with a brown paper gasket at the joint.

Single Camshaft Operates Valves

All the valves are operated by a single camshaft. It is supported in four bearings, the rear being a large ball bearing and the remainder phosphor bronze. The shaft is driven off the end of the crankshaft through the recesses of steel gears supported, as already mentioned, between ball bearings housed in the top portion of crankcase and forming gear cover.

The induction manifold is of steel, with branches to each inlet valve port. A heated metal is provided in the central section, a pipe being taken from the exhaust manifold so that the exhaust gases can circulate therein. The joints between the induction manifold cylinder head, and carburetor, are made with "Hulite" gaskets.

The lower half of the crankcase holds sufficient oil for about five hours' flight. The oil pump is arranged at the lower part of the case, so that it is always flooded, or self-primed with oil. The pump, which is a gear type, forces the oil through a gauge filter, which is arranged horizontally just above the pump, thence through the main delivery pipe to the oil gallery arranged on the port side of the engine. The oil gallery is connected to passages cast in the top half of the crankcase, which runs to the outer and intermediate bearings, the oil is then forced under pressure direct to each bearing.

(Continued at top of page 1042)

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The sports plays in each cylinder are placed at opposite sides of the combustion chamber. Twin Bosch-Thomson-Houston high tension magnets are internally used, but these will be replaced by Scintilla magnets in the Cirrus engines made in this country. The Claudel-Hobson carburetor also will be replaced by one of American manufacture.

The main advantages of the engine are its simplicity and reliability, and the fact that it can be mounted in the nose of a plane with a minimum of head resistance and obstruction to view. The engine is said to have another



DeHavilland "Mosk" powered with a Cirrus engine.

advantage in that it requires no greater skill for its maintenance than an ordinary automobile engine.

The American Cirrus company does not intend to manufacture planes. Its policy will be to co-operate with plane constructors and designers in every possible way, particularly as regards installation problems.

The specifications of the Cirrus Mark III engine are as follows:

Type	Four cylinder-in-line, vertical
Number of cylinders	Four
Cooling	Air
Rated horsepower	170 at 2,250 r.p.m.
Stroke	5.3 in.
Displacement	381 cu. in.
Compression ratio	16 to 1
Normal b. hp.	85 at 1,900 r.p.m.
Maximum b. hp.	95 at 2,100 r.p.m.
Weight dry	286 lb.
Fuel consumption	54 lb. per b. hp. hr.
Oil consumption	2.03 lb. per b. hp. hr.
Direction of rotation	Clockwise
Service	Two magneto
Tachometer	36 engine speed
Length overall	29.5 in.
Height overall	23.5 in.
Width overall	12.25 in.
Best air speed	117.5 in.

Use of Monel Metal and Nickel in Aircraft

(Continued from page 1610)

reducing side is used, and the horns have flares. The metal of a welded joint is not so strong as the unfused metal, if the weld is ground down smooth with the sheet it not ground down, equal strength can be relied upon. The practice for carburetor welding of monel metal and nickel is exactly the same as for steel, but this type of welding is not generally recommended. Monel metal and nickel can be successfully spot-welded on any of the spot-welding machines on the market. With some experience brittle welds and burning are avoided. It requires a close



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Ordinary methods are used in soldering mixed metal and nickel. Where a soldering seam will be strong enough for intended service, this method of joining is recommended as the most convenient. Strong lap-joints can be made by soldering, one chlorine hydrochloric acid flux and various paste fluxes work well. Surfaces to be



A step at the bottom of one of the Navy's mixed metal aircraft floats. This photograph was taken while the float was in the course of construction. The stringers and frames are shown clearly.

joined must be thoroughly cleaned by polishing with fine abrasive, followed by washing or in some cases by acid cleaning. Stronger bonds are obtained with silver solder, brazing solder, or nickel silver than with soft solder. Such joints are strongly recommended where the high soldering temperatures are not a drawback. Mixed metal and nickel construction may well be joined by covering, preferably in the cold.

Steel and mixed metal are quite similar in drawing and forming capacity, the degree in which mixed metal can be deformed without fracture, depending of course on the actual temper. Soft temper is best for operations requiring extension in sections, but harder tempers can be used where the work is confined to bending. Intensive cold working requires intermediate annealing.

Mixed metal and nickel may be machined without difficulty, cold-worked metal more easily than soft metal. General fabrication is generally essential. Tools should be ground with a sharp cutting angle—considerable back or rake. Precautions should be taken to eliminate that of machinery steel for the same piece. Mixed metal and nickel are both of good forging character. Forgings carry mechanical properties to the relief of those for hot-rolled metal, sometimes better. Castings in mixed metal and nickel are turned out by various foundries throughout the country. Conventionally sound metal is normally to be expected. The main deficiency in cast metals is general loss in their reliability for mechanical properties. The following values apply to cast metal:

Tensile psi	60-75,000 psi
Yield point	30-40,000 psi
Elong in 2"	25-35%

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Standard 1/8" 1/4" 3/8" 1/2" 5/8" 3/4" 1" 1 1/4" 1 1/2" 1 3/4" 2" 2 1/4" 2 1/2" 2 3/4" 3" 3 1/4" 3 1/2" 3 3/4" 4" 4 1/4" 4 1/2" 4 3/4" 5" 5 1/4" 5 1/2" 5 3/4" 6" 6 1/4" 6 1/2" 6 3/4" 7" 7 1/4" 7 1/2" 7 3/4" 8" 8 1/4" 8 1/2" 8 3/4" 9" 9 1/4" 9 1/2" 9 3/4" 10" 10 1/4" 10 1/2" 10 3/4" 11" 11 1/4" 11 1/2" 11 3/4" 12" 12 1/4" 12 1/2" 12 3/4" 13" 13 1/4" 13 1/2" 13 3/4" 14" 14 1/4" 14 1/2" 14 3/4" 15" 15 1/4" 15 1/2" 15 3/4" 16" 16 1/4" 16 1/2" 16 3/4" 17" 17 1/4" 17 1/2" 17 3/4" 18" 18 1/4" 18 1/2" 18 3/4" 19" 19 1/4" 19 1/2" 19 3/4" 20" 20 1/4" 20 1/2" 20 3/4" 21" 21 1/4" 21 1/2" 21 3/4" 22" 22 1/4" 22 1/2" 22 3/4" 23" 23 1/4" 23 1/2" 23 3/4" 24" 24 1/4" 24 1/2" 24 3/4" 25" 25 1/4" 25 1/2" 25 3/4" 26" 26 1/4" 26 1/2" 26 3/4" 27" 27 1/4" 27 1/2" 27 3/4" 28" 28 1/4" 28 1/2" 28 3/4" 29" 29 1/4" 29 1/2" 29 3/4" 30" 30 1/4" 30 1/2" 30 3/4" 31" 31 1/4" 31 1/2" 31 3/4" 32" 32 1/4" 32 1/2" 32 3/4" 33" 33 1/4" 33 1/2" 33 3/4" 34" 34 1/4" 34 1/2" 34 3/4" 35" 35 1/4" 35 1/2" 35 3/4" 36" 36 1/4" 36 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